

# Work Order ID 90719

September-24-12 2:36:40 PM

**\*90719\***

Page 1

Item ID: D3065-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Step Leg Assembly Hi  
 Start Date: 9/24/12 Start Qty: 20.00 **\*20\*** Cust Item ID:  
 Required Date: 10/19/12 Req'd Qty: 20.00 **\*20\*** Customer:  
 Reference:

Approvals: Process Plan: ML5 Date: 12-09-24 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_  
 Run Start **\*NR1\***  
 Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D3065	Rev B								
100	Small Fab	0.00							
<b>*100*</b>									
Small Fab	Memo	0.00							
Small Fab	Assemble as per Dwg D3065 and Identify as D3065-041								
110	QC5- Inspect part completeness to step on W/O	0.00							
<b>*110*</b>									
QC	Memo	0.00							
Quality Control									
120	Identify as per dwg & Stock Location: <u>WA</u>	0.00							
<b>*120*</b>									
Packaging	Memo	0.00							
Packaging									

20x 12/11/19

20 0 12.11.22

20 0 12/11/22

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**\*90719\***

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Item ID: D3065-041

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Item Name: Step Leg Assembly Hi

Stop **\*NS2\***

Start Date: 9/24/12 Start Qty: 20.00

**\*20\***

Cust Item ID:

Required Date: 10/19/12 Req'd Qty: 20.00

**\*20\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC21- Final Inspection - Work Order Release

0.00

**\*130\***

QC

Memo

0.00

Quality Control

12/12/22

MK  
12-1222

# Picklist Print

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Work Order ID: 90719

Parent Item: D3065-041

Parent Item Name: Step Leg Assembly Hi

Start Date: 9/24/12

Required Date: 10/19/12

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev: C02.11.01 Incorporated D3066-1 IPPKJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3065-1 Step Spacer		Manufactured	No			100	Each	61.0000	1	20		9/24/15	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		61							
				74497		1							
				81303		1							
				83733		29							
				88825		30							
D3065-3 Step Spacer		Manufactured	No			100	Each	62.0000	1	20		9/24/15	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		62							
				69827		1							
				73290		4							
				75152		14							
				83734		12							
				83873		1							
				88826		30							
D3065-5 Step Leg		Manufactured	No			100	Each	120.0000	2	40		9/24/15	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		120							
				67222		1							
				73289		19							
				88827		80							
				89239		20							

B90766 (5)  
B91635 (52)

B89939  
(202)

B90073  
(402)

# Picklist Print

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Work Order ID: 90719

Parent Item: D3065-041

Parent Item Name: Step Leg Assembly Hi

Start Date: 9/24/12

Required Date: 10/19/12

Start Qty: 20.00

Required Qty: 20.00

D3065-7  
Step Spacer

Manufactured No

100 Each 91.0000 1

20

Location

Loc Qty

Loc Code

GA	91
73291	7
74499	1
78666	4
83738	1
85471	8
88828	30
89972	40

*Handwritten:* 12/11/14  
B 90520  
~~390657~~ (20x)

MS20470AD4-4  
Rivet, Universal Head

Purchased No

100 Each 7,382.0000 30 600

30

Location

Loc Qty

Loc Code

ST313	2662
122027	2600
122063	62
ST319	4720
116188	136
116391	66
118614	884
119109	26
121011	5
121556	603
121652	3000

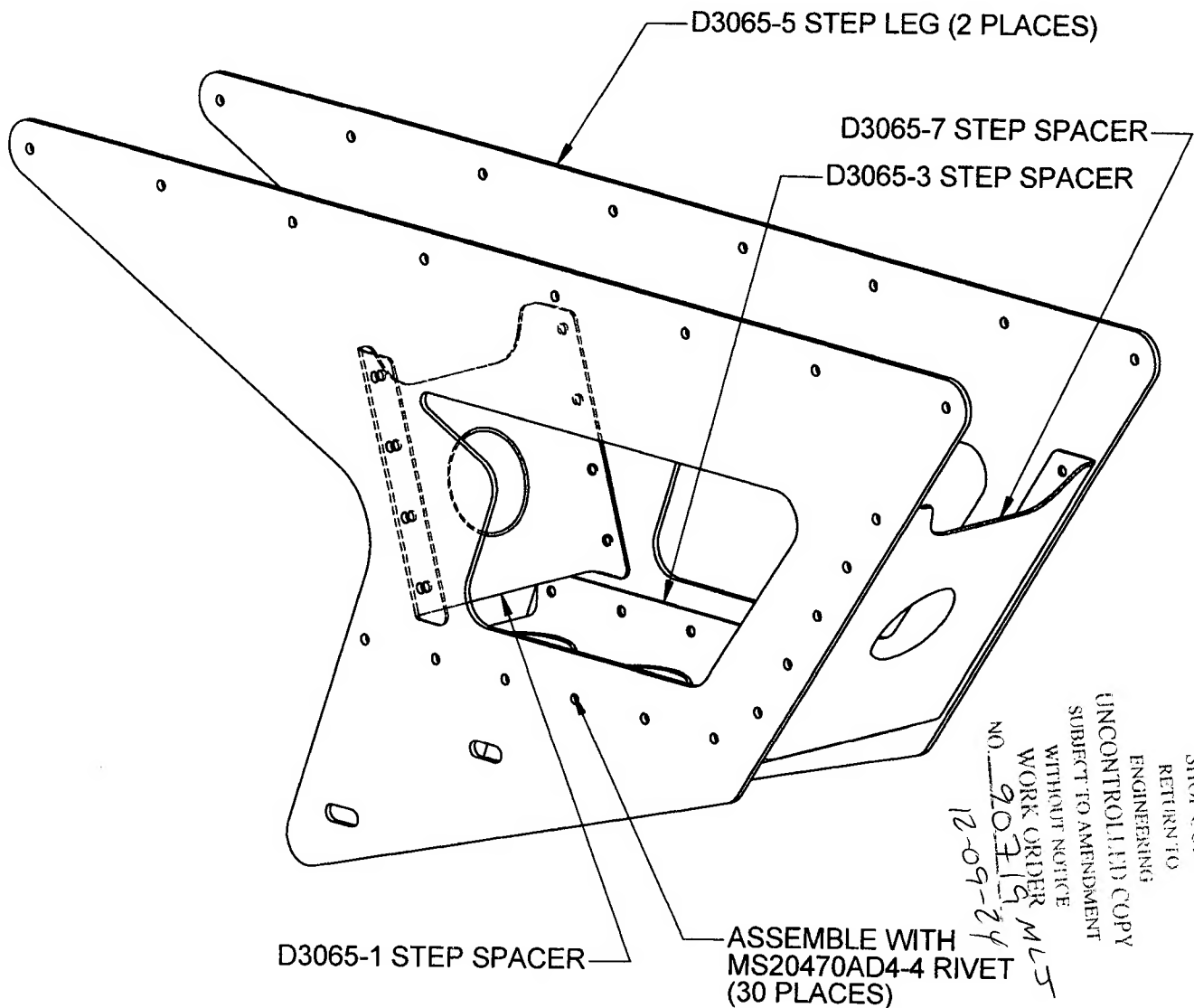
*Handwritten:* 12/11/15  
M123352  
(600x)

**DART**

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3065</b>	REV. B SHEET 1 OF 5
DATE <b>06.05.23</b>		TITLE <b>STEP LEG ASSEMBLY</b>	SCALE 1:2
A	02.09.11	NEW ISSUE	
B	06.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5	

**RELEASED**

*06.06.20* *[Signature]*




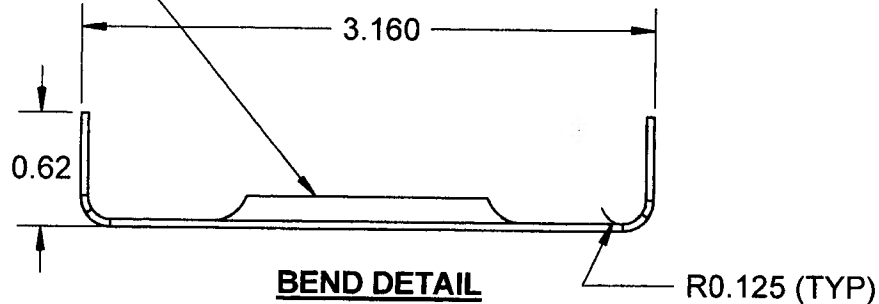
**D3065-041 STEP LEG ASSEMBLY**

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### D3065-1 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)  
2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1  
3) BREAK ALL SHARP EDGES 0.005 TO 0.010  
4) PART IS SYMMETRIC ABOUT CENTERLINE  
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
6) ALL DIMENSIONS ARE IN INCHES

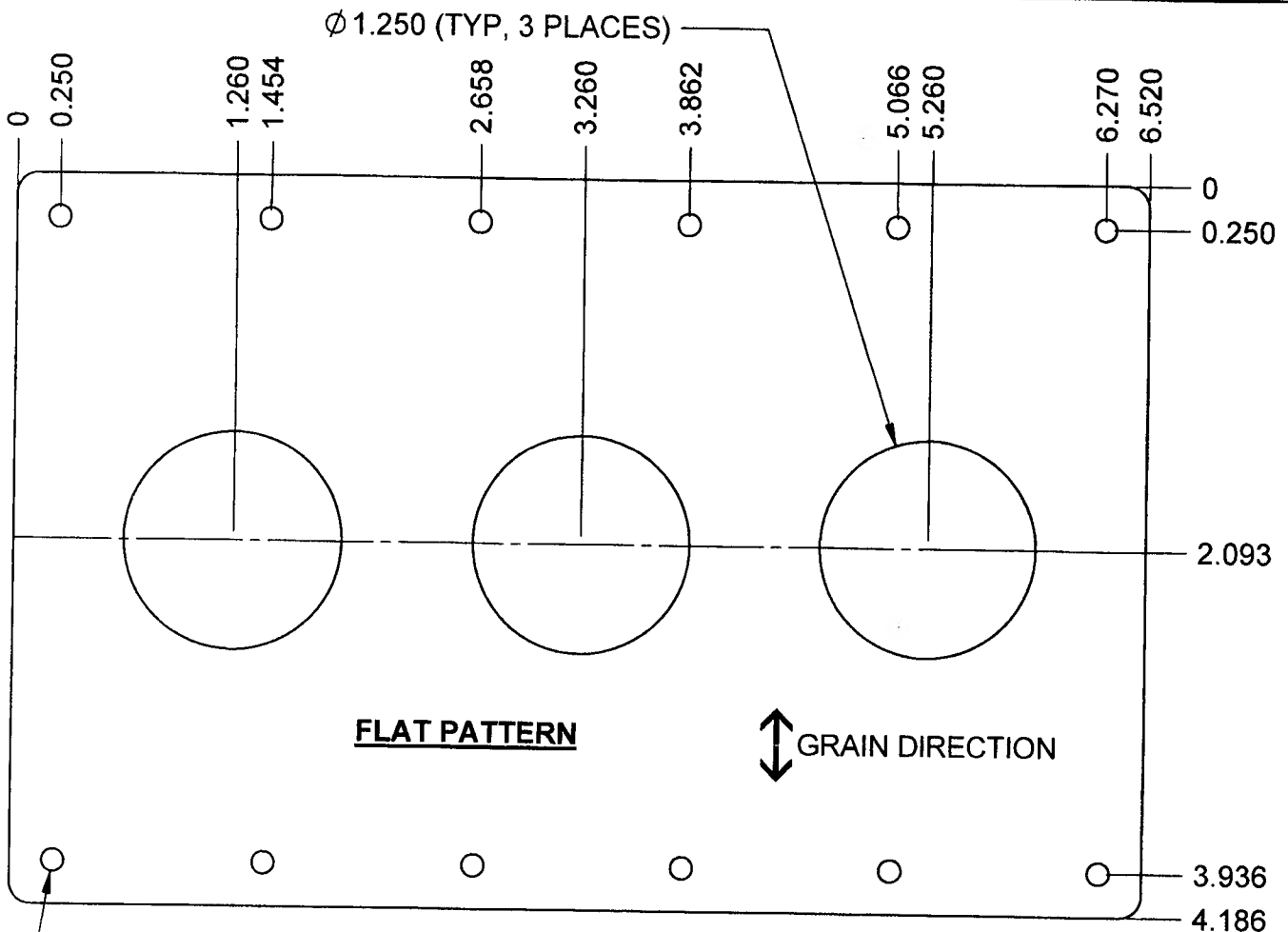
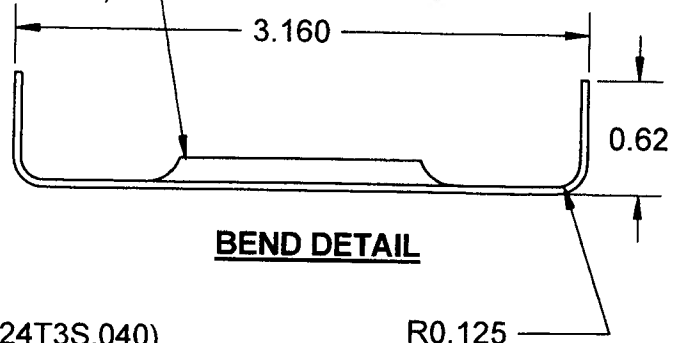
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61t06

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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3065</b>	REV. B SHEET 3 OF 5
DATE <b>06.05.23</b>		TITLE <b>STEP LEG ASSEMBLY</b>	SCALE 1:1

**FLAT PATTERN****GRAIN DIRECTION**FLANGE AFTER TOWARDS SIDE  
SHOWN USING DT8174 (3 PLACES) $\phi 0.129$  (TYP, 12 PLACES)**RELEASED***06.06.20***BEND DETAIL****D3065-3 STEP SPACER**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4)  
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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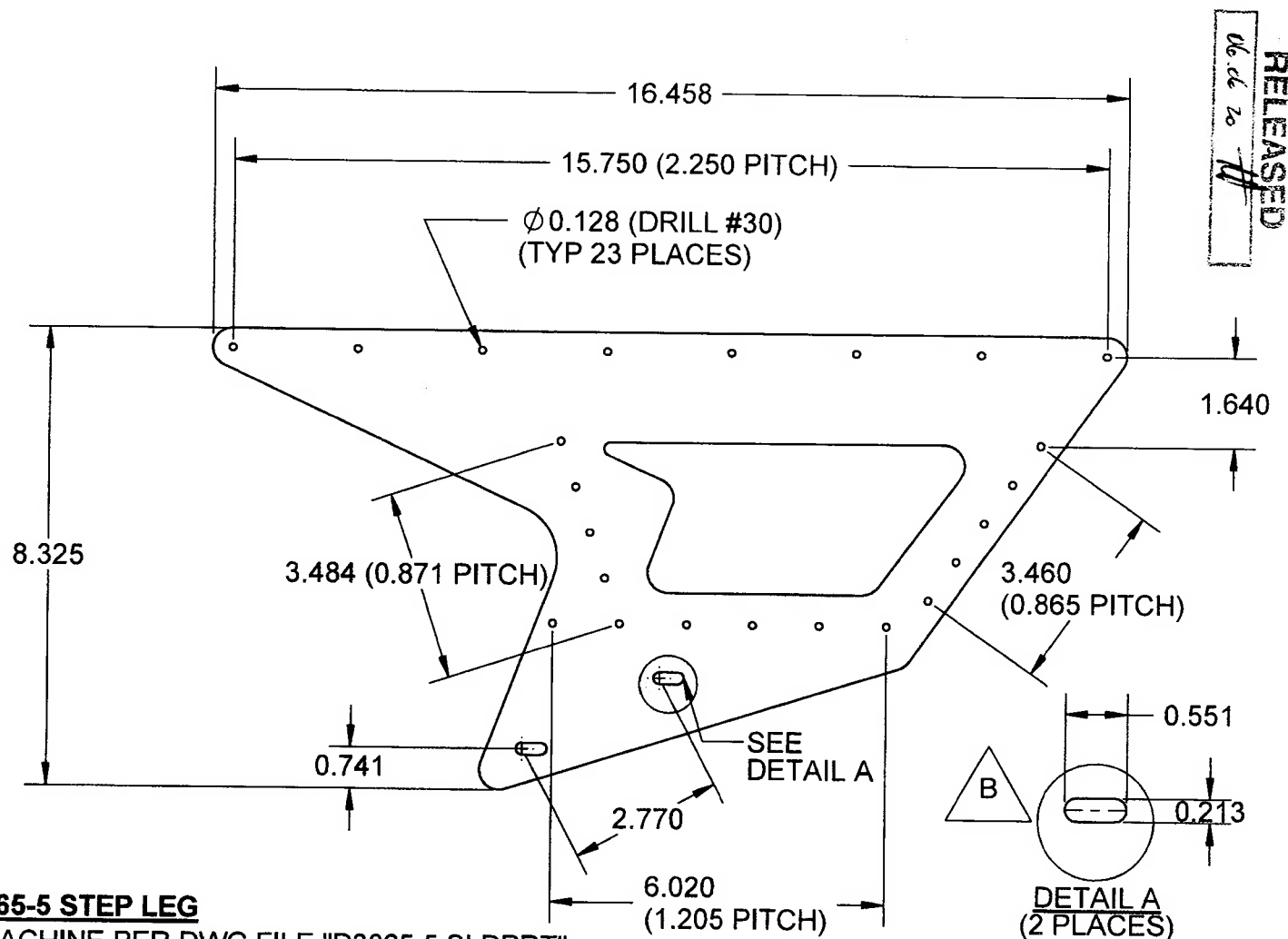
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61706

90719

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CHECKED	APPROVED	DRAWING NO.	HAWKESBURY, ONTARIO, CANADA
DATE	06.05.23	TITLE	STEP LEG ASSEMBLY
		SCALE	1:3
		REV. B	SHEET 4 OF 5

**D3065-5 STEP LEG**

- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
- 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080) OR 5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

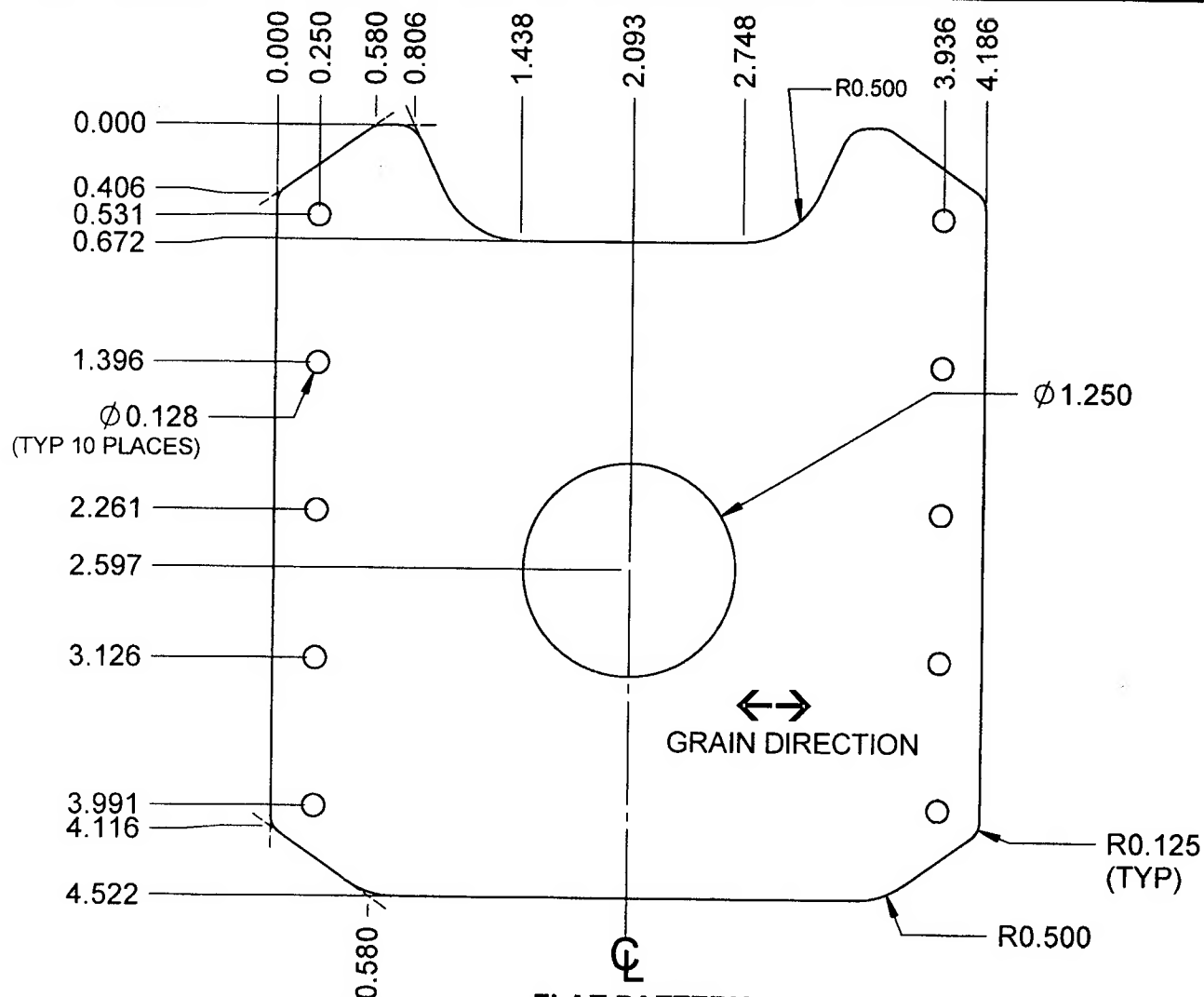
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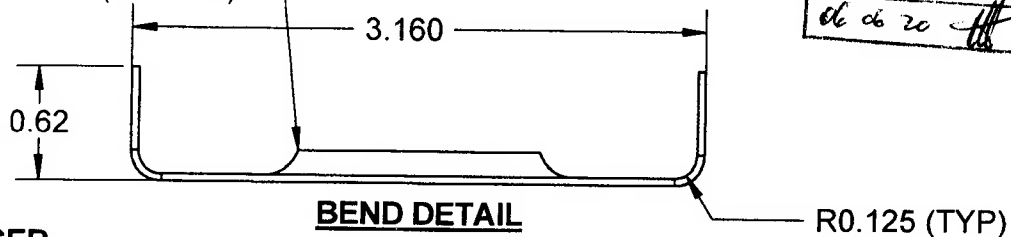




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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 5 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	
		SCALE 1:1	



FLANGE AFTER BENDING TOWARDS  
SIDE SHOWN USING DT8174 (2 PLACES)



RELEASED

### D3065-7 STEP SPACER

- 1) MATERIAL: 2024-T3 (PER QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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